110

QC2- Inspect parts off machine FAI/FAIB

0.00

PL, 13/05/25

110

QC

Memo

0.00

60 Ø

Quality Control

NCR: Y	es / No				WORK ORDER NON-C	CONF	ORN	MANCE / UPI	DATE	QA Closed:	Date	2:
Work Orde	r:				DISPOSITION				_	EPARTMENT,	/PROCESS	
Part N	0			·	Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0				Work Order Update]		Large Fab	Composite		Supplier	<u> </u>
Root				Descri	ption of work order update	Ini	tial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chie	f Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data												
quip/Tooling												
Operator												
/laterial												
etup												
Other	_											
rocess	_											
upplier	_			,								
raining												
Inapproved							_		•	<u> </u>		
						AULT	CATE	GORY				
Landin	g Gear				General				_	-		¬₋
ļ	Bending				Bend	\mathbf{H}	rain			Ovalized		Pressure/Forced
1	Centre N	ot Conce	ntric to	o/s	BOM/Route	\vdash	ardwa			Over/Under		Temperature/Cure
,	Cracks				Broken/Damaged	_	•	on Incomplete	<u> </u>	Part Incorre	-	Weld
]	Crushed,	/Crimped		<u> </u>	Burrs	\vdash		ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
·	Cuffs			<u>_</u>	Contamination	\vdash		nance		Part Moved		
	Heat Tre	at			Countersink	\square^{\wedge}	lislabe	led		Positioned V		_
ļ	Inspection	on Strip in	Tube	<u></u>	Cut Too Short		isreac	j		Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes	-	ffset					
	Torque V	Vaves in E	extrusio	n L	Drawing		ut of (Calibration				
	Turning :	Sequence			Finish		ut of S	Sequence				
_	Wave/Tv	vist in Tul	ре		Folio	0	utside	Dimensions				<u> </u>

DQA:

Date:

May-21-13 3:43:43 PM

Item ID: D4048-9 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bushing **Start Date:** 5/21/13 **Start Qty:** 60.00 *60* Cust Item ID: Required Date: 6/04/13 Req'd Qty: 60.00 *60* **Customer:** Reference: Run Process Plan: ____ Date:____ **Approvals:** Tooling: Date: Stop QC: _____ Date: _ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 120 QC8- Inspect parts - second check 0.00 *120* 13-5-27 Memo 0.00 Quality Control Identify as per dwg & Stock Location: 130 *130* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140* 0.00 Memo Quality Control

								DQA:	Date:	
NCR: Yes	s / No			WORK ORDER NON-	CONFORI	MANCE / UP		QA Closed:	Date:	
Marila Ondani				DISPOSITION	-		AGAINST DE	PARTMENT	/PROCESS	
Work Order:				Rework]	Skid-tube	Crosstube		Water Jet	Engineering
Part No.	•			Scrap	- I	Machining	Small Fab		d. Eng. Coor.	Quality
NCR No.	•			Use-as-is Work Order Update	Therr	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Description of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling					1					
Operator		ļ			-					
Material										
Setup					1					
Other						1				
Process							•			
Supplier										
Training										

Landing Gear Pressure/Forced Bend Ovalized Bending Grain Temperature/Cure BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Weld Part Incorrect Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Part Moved Cuffs Maintenance Contamination Countersink Mislabeled Positioned Wrong Heat Treat Misread Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Drill Holes Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Finish Out of Sequence Turning Sequence Folio Outside Dimensions Wave/Twist in Tube

FAULT CATEGORY

General

Unapproved

Picklist Print

May-21-13 3:43:46 PM

Work Order ID: 101968

Parent Item:

D4048-9

Parent Item Name: Bushing

101968

D4048-9

Start Date: 5/21/13

Required Date: 6/04/13

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP REV:A NEW ISSUE 10-01-07 JLM VERIFIED BY:DD IPP Rev:B

as per dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.500		Purchased	No			100	f	38.1240	0.037	2.336842			
M304R 5	ი ი								**	_,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			

304 SS roundbar .500

Location Loc Qty Loc Code MAT029 38.124 **×**115334 2.34' F.K. 13/05/25 18.27 117890 19.854

Page 1

NCR:	Yes	1	No
		,	

DQA: _____ Date: _____

NCR: Y	es / No				WORK ORDER NON-	CONFO	KIVIANCE / UP	DATE	QA Closed:	Date	::
Work Orde	j.				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	1	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update	∃ Th€	rmoforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root				Desci	ription of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	ng Desc	ription	Date	Verification	QC Inspector
oc/Data	_										
quip/Tooling			•								
perator	_	1									
/laterial	_	ĺ									
etup				٠.							
Other	_	·									
rocess	_										
upplier	4										
raining	4									·	
Inapproved			<u> </u>			501117.60	TECODY				
		· · · · -				FAULT CA	IEGORY				
Landin T	_			г	General Bend	Grai	_		Ovalized	Г	Pressure/Forced
-	Bending	lot Conce	_4_:_4_	o/s -	BOM/Route	Hard		—	Over/Under	toloranco	Temperature/Cure
-	Cracks	iot conce	nunc to	^{0/3} -	Broken/Damaged	\vdash	ction Incomplete	\vdash	Part Incorred		Weld
-	→	/Crimped		-	Burrs	-	action incomplete/	Inclear	Part Lost/Mi)	Wrong Stock Pulled
-	Cuffs	Cimpeu		-	Contamination	— —	itenance		Part Moved	33116	
ŀ	Heat Tre	at		-	Countersink	\vdash	beled		Positioned V	Vrong	
ŀ		on Strip in	Tube	<u> </u>	Cut Too Short	Misro			Power Loss/		Other
ŀ	Ripples i		·usc	F	Drill Holes	Offse			1. 22. 2333		. 1
-	→ ``	Naves in I	Extrusio	, F	Drawing	\mathbf{H}	of Calibration				
ŀ	_	Sequence		·	Finish	—	of Sequence				· · · · · · · · · · · · · · · · · · ·
<u> </u>		wist in Tul		一	Folio		de Dimensions	•		-	

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	101968
Description: Bushing	Part Number:	D4048-9
Inspection Dwg: D4048 Rev: A		Page 1 of 1

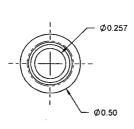
FIRST ARTICLE INSPECTION CHECKLIST

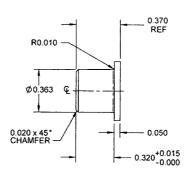
·		AKTICLE IN	<u> </u>		U112101	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	.257	70 V		F.K 04	Yen.
0.50	+/-0.030	°468	DV		0	h
R0.010	+/-0.015	R.010	TAV		n	•
0.370	+/-0.010	.377	VV		(-	k
0.050	+/-0.010 • 0 4 ⁰	,4933b	XV			r
0.320	+0.015/-0.000	°352	A.		<i>)</i> ,	1
0.020 x 45°	+/-0.010 x +/-0.5°	020 x450	1		þ	a
0.363	+/-0.010	,360	W.V		٨	ı
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Measured by:	FK	Audited by:	్థిచెస్ట్ర	Preliminary Approval:	
Date:	13/05/25	Date:	13-5-27	Date:	

Rev	Date	Change	Revised by Approved
Α	10.06.08	New Issue	KJ 90







42 67 87 O A WAY ROLL D'COPY MERCEN AND DECE 1305-72

## D4048-9 BUSHING

NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD					
DRAWN	RF.	HAWKESBURY, ONTARIO, CANADA					
CHECKED	Q.	DRAWING NO.	REV. A				
MFG. APPR.	94	D4048	SHEET 9 OF 9				
APPROVED	140	TITLE	SCALE				
DE APPR.	_#	MOUNTING LUG ASSY	NTS				
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPA THIS DOCUMENT IS PREVATE AND COMPIDENTIAL AND IS SUPPLIED ON THE EXPR NOT TO BE USED FOR ANY PURPOSE OR COMPIDED OR COMMUNICATED TO ANY WRITTEN PERMISSION FROM BARY AEROSPACEL TO	ESS CONDITION THUS IT IS				

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